

5/42

Adj 43

DART AEROSPACE LTD		Work Order:	24345
Description: Bracket		Part Number:	D3156-1
Dwg: D3156 Rev. B		Qty:	72 6 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10		05.09.26	10
2	MV	Cut blank: 1.950" x 0.700" grain along 1.950" Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3156-1		05/10/27	12
3	MV GA	Machine as per Folio FA477 and Dwg D3156 Stack of 10 Identify as D3156-1	ml	05/10/27	6
4	QC2	Inspect parts as they come off the CNC machine			
5	QC8	Second check			
6	GA	Deburr	ml	05/10/27	72
7	GA	Form as per Dwg D3156	ml	05/10/27	72
8	QC5	Inspect work to Step 7	TT	05/11/03	6
9	FP	Chemical Conversion Coat as per QSI 005 4.1	ml	05/11/03	6
10	QC3	Inspect Chemical Conversion Coat	SB	05/11/03	6
11	ST	Identify with part number and batch number using fine point permanent ink marker, and Stock	ml	05/11/03	6
12	AC	Cost / part: <u>15, 64</u>	54C	05-11-10	6
13	DC	Close W/O 10.97 Inspect Level 21	(S)	05/11/07	10

Rev	Date	Change	Revised By	Approved
A	04.11.30	New issue	KJ/JLM	JLM

RELEASED
05/12/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/10/31	7	Bad dimension of holes and band	AB 05/10/07	Scrap 12 pieces of D 3156-1 Replace by 6 pieces	ml 05/10/31 05.11.07		AB 05/10/07	05/11/07

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No DQA: 

Date: 05/11/07

NOTE: Date & initial all entries

QA: N/C Closed: _____

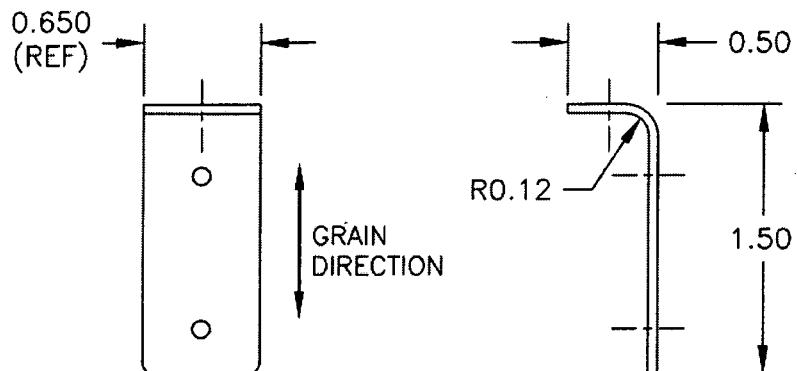
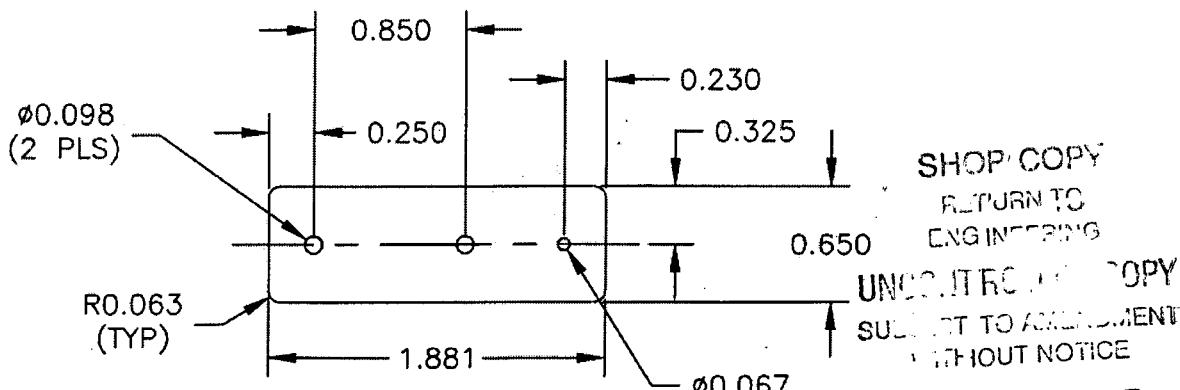
Date: _____

DARTCOPY
SHEET
1 OF 1

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D3156 SHEET 1 OF 1
DATE		TITLE SCALE
04.10.18		BRACKET 1:1
A	02.04.24	NEW ISSUE
B	04.10.18	ADD PART MARKING

RELEASED

04.11.23

**D3156-1 BRACKET****D3156-1 BRACKET FLAT PATTERN**

WORK ORDER
NO. 24345

#51

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-117
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024345
 Project Name : D3156-1
 Project For : WK542
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3156-1
 Description : Bracket
 Manufactured : Yes
 Amount Req'd : 10
 Amount Done : 0
 Start Date : 09-26-05
 Est Finish Date : 10-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:44 am

Work Order No : 0024345
 Project Name : D3156-1
 Project For : WK542
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3156-1
 Description : Bracket
 Manufactured : Yes
 Amount Req'd : 10
 Amount Done : 0
 Start Date : 09-26-05
 Est Finish Date : 10-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	5.50	100.00		
Production Cost :	0.00	93.44	100.00	0.00	93.44
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	93.44	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	93.44			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-93.44)